

Work Order ID 157225

Tuesday, February 21, 2017 7:57:33 AM

157225

Page 1

Item ID: D4703-043

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Lock Pin Base

Start Date: 2/3/2017

Start Qty: 6.00

6

Cust Item ID:

Required Date: 2/17/2017

Req'd Qty: 6.00

6

Customer:

Reference:

Approvals:

Process Plan:

DAS

21

Date: FEB 22 2017

Tooling:

Date:

Run Start ***NR1***

QC:

9-89

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D4703

A

100

Cut blanks as per folio

0.00

100

Bandsaw

Memo

0.08

Jeaspa Bandsaw

CUT BLANK AT 2.6"

10

Ø

DAS

44

9-89

17-03-0

110

0.00

110

HAAS 1

Memo

0.26

HAAS CNC vertical machine #1

MACHINE AS PER DWG & FOLIO FB132

FOLIO REV: ADWG REV: A

10

Ø

DAS

44

9-89

17-03-07

DEBURR

Work Order ID 157225***157225***

Page 3

Tuesday, February 21, 2017 7:57:33 AM

Item ID: D4703-043 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Lock Pin Base
Start Date: 2/3/2017 Start Qty: 6.00 ***6*** Cust Item ID:
Required Date: 2/17/2017 Req'd Qty: 6.00 ***6*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
134	Receive & Inspect for Damage & Mat'l Certs	0.00							
134									
Packaging	Memo	0.02							
Packaging									
136	QC3- Inspect Part Finish	0.00							
136									
QC	Memo	0.01							
Quality Control									
137		0.00							
137									
Small Fab	Memo	0.15							
Small Fab	INSERT HELICOIL								

10x8017-03-20

10 0 17-3-30

DAS 38 9-89

MAR 29 2017

DAS 19 9-89

Work Order ID 157225

Tuesday, February 21, 2017 7:57:33 AM

157225

Page 4

Item ID: D4703-043 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Lock Pin Base
Start Date: 2/3/2017 Start Qty: 6.00 ***6*** Cust Item ID:
Required Date: 2/17/2017 Req'd Qty: 6.00 ***6*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
138 *138* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.02				<u>10</u>			DAS 38 9-89 MAR 3 0 2017
140 *140* Packaging Packaging	Identify as per dwg & Stock Location: <u>ST119</u> Memo	0.00 0.01	DAS 6 9-89	DAS 6 9-89		<u>10</u>			DAS 41 9-89 MAR 3 0 2017
150 *150* QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.10						<u>17/4/3</u>	DAS 21 9-89 MAR 3 1 2017

Picklist Print

Tuesday, February 21, 2017 7:57:36 AM

Page 1

Work Order ID: 157225

157225

Parent Item: D4703-043

D4703-043

Parent Item Name: Lock Pin Base

Start Date: 2/3/2017

Required Date: 2/17/2017

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP REV:A NEW ISSUE 12-09-12 JLM VERIFIED BY:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6B0.750X01.00 0		Purchased	No			100	f	23.3660	0.22	1.389474			

M6061T6B0 750X01 000

6061-T6 Bar .750 x 1.00

**

DAS
44
9-89

17-03-07

Location

Loc Qty

Loc Code

MAT

23.366

m134705

23.366

2.31

MS21209-F415

Purchased

No

137

Each

27.0000

1

6

MS21209-F415

Heli-Coil

**

17-3-30

DAS
19
9-89

Location

Loc Qty

Loc Code

ST296

27

M133640

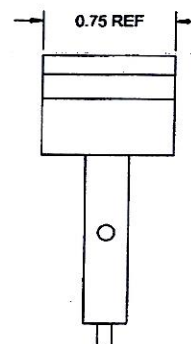
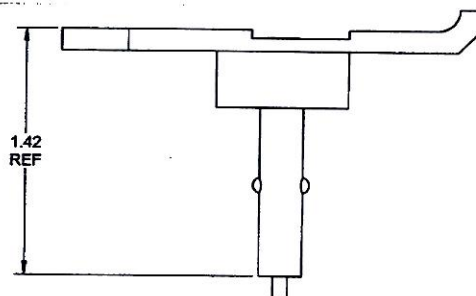
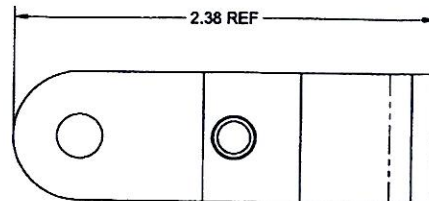
2

M136643

25

10

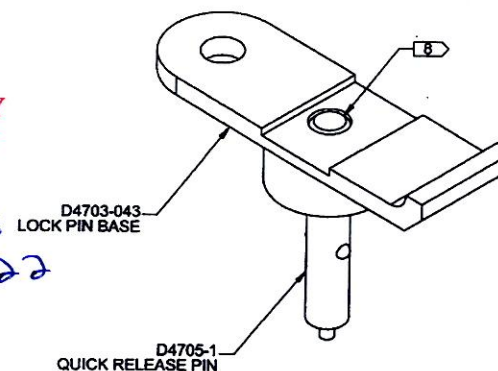
ITEM	QTY	P/N	DESCRIPTION
	X	D4703-041	LOCK PIN ASSY
1	1	D4705-1	QUICK RELEASE PIN
2	1	D4703-043	LOCK PIN BASE



D4703-041 LOCK PIN ASSY

**SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 157225 M.S**

1702-22



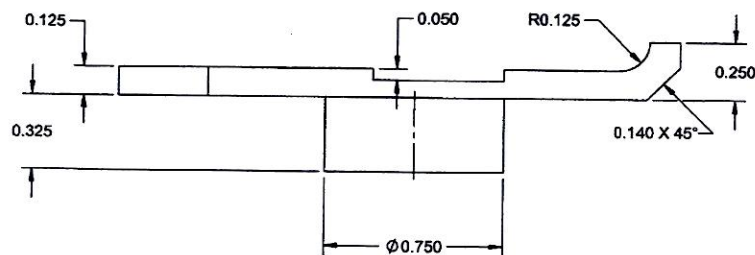
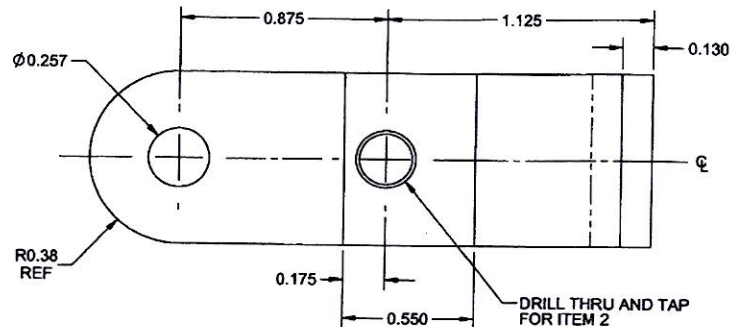
RELEASED
2012-10-12

NOTES:

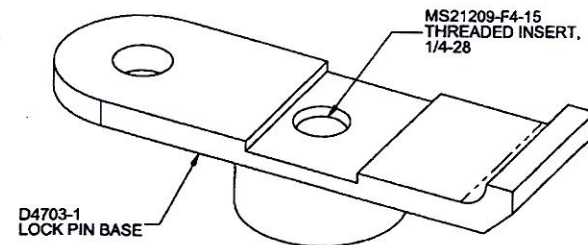
- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4703-041" AND B/N "BXXXXX" PER QSI 044 6.1
- 7) WEIGHT: 0.05 lbs
- 8) APPLY LOCTITE 262 TO D4703-043 THREADS PRIOR TO FASTENING D4705-1

A		NEW ISSUE		RP	12.09.19
REV.	DESCRIPTION			BY	DATE
DESIGN	RP	DART AEROSPACE USA, INC.			
DRAWN	RP	KENT, WA			
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. A		
MFG. APPR.	<i>[Signature]</i>	D4703	SHEET 1 OF 2		
APPROVED	<i>[Signature]</i>	TITLE	SCALE		
DE APPR.	<i>[Signature]</i>	LOCK PIN ASSY	NTS		
DATE	12.09.19	COPYRIGHT © 2012 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.			

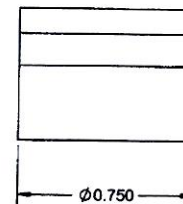
ITEM	QTY.	P/N	DESCRIPTION
	X	D4703-043	LOCK PIN BASE
1	1	D4703-1	LOCK PIN BASE
2	1	MS21209-F4-15	THREADED INSERT, 1/4-28



D4703-1 LOCK PIN BASE



D4703-043 LOCK PIN BASE



RELEASED
2012-10-12

NOTES:

- 1) MATERIAL: 6061-T6/T651 PER QQ-A-200/8 OR QQ-A-225/8 OR ASTM B211 OR ASTM B221 REF. DART SPEC. M6061T6B
- 2) FINISH: BLACK ANODIZE PER MIL-8625F, TYPE III, CLASS 2
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.04 lbs

DESIGN	RP	DART AEROSPACE USA, INC.	
DRAWN	RP	KENT, WA	
CHECKED	A.P.	DRAWING NO.	REV. A
MFG. APPR.		D4703	SHEET 2 OF 2
APPROVED		TITLE	SCALE
DE APPR.		LOCK PIN ASSY	NTS
DATE	12.09.19	COPYRIGHT © 2012 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS COVENANT THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED IN ANY MANNER WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID **PO35698**

Purchase Order Date 3/23/2017

PO Print Date 3/29/2017

Page Number 5 of 6

Order From :

A.T.G. INDUSTRIES INC.
731 INDUSTRIELLE ROAD
ROCKLAND, ON K4K 1T2
CANADA

VC-ATG001

Ship To : DART AEROSPACE LTD

1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

Contact Name

Vendor Phone 613-446-4544

Ship To Contact

Ship To Phone

Ship Via: VENDOR'S TRUCK

Ship Acct:

Buyer

Customer POID

Customer Tax #

Terms

Currency

FOB

Chantal Lavoie

10127-2607

Net 30

CAD

FCA - (Free Carrier)

12	157320	D4726-1 HANDLE REV. A	4/6/2017	4.00	\$2.70	\$10.80
			Yes 4/6/2017			
		ANODIZE AS PER MIL-A-8625F, TYPE III, CLASS 2, COLOR BLACK				

Line Total: \$10.80

13	158157	D2348 WEARPLATE REV. C	4/6/2017	12.00	\$8.33	\$99.96
			Yes 4/6/2017			
		ANODIZE AS PER MIL-A-8625F, TYPE I/IB//C/II/IIB, CLASS 2, COLOR BLACK				

Line Total: \$99.96

14	157225	D4703-043 LOCK PIN REV. A	4/6/2017	10.00	\$2.70	\$27.00
			Yes 4/6/2017			
		ANODIZE AS PER MIL-A-8625F, TYPE III, CLASS 2, COLOR BLACK				

Line Total: \$27.00

PO Instructions: PRIMER IS SUPPLIED BY DART

Note:

3/29/2017

Sp17-B-29



A.T.G. INDUSTRIES INC.
731 INDUSTRIELLE STREET
ROCKLAND, ON K4K 1T2
Canada

Ph: (613) 446-4544

Fax: (613) 446-4556

Pack List

Number: 913105

Date: 28-Mar-17

To

Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ship To

Chantal Lavoie
Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ph: 613 632-9577

Fax: 613 632-1053

Ph: 613 632-9577

Fax: 613 632-1053

Terms		Ship Via	
Quantity	Description		
	PLEASE REFERENCE THE PACK LIST NUMBER ON ALL CORRESPONDENCE TO THIS SHIPMENT. IF YOU HAVE ANY QUESTIONS, PLEASE CALL AT (613) 446-4544.		
3 ea	Part: D5155-047 Co-Pilot Black Anodize per MIL-A-8625F, Type II, Class 2 Job: 20850	Rev: B PO: PO35698	Line: 1
4 ea	Part: D4726-1 Handle Black Anodize per MIL-A-8625F, Type II, Class 2 Job: 20864	Rev: A PO: PO35698	Line: 12
12 ea	Part: D2348 Wearplate Black Anodize per MIL-A-8625F, Type II, Class 2 Job: 20865	Rev: C PO: PO35698	Line: 13
10 ea	Part: D4703-043 Lock pin Black Anodize per MIL-A-8625F, Type II, Class 2 Job: 20866	Rev: A PO: PO35698	Line: 14
9 ea	Part: 646.3810 Bracket Hard Black Anodize per MIL-A-8625F, Type III, Class 2 Prime per MIL-PRF-23377, Type I, Class N (Customer Supplied) Job: 20852	Rev: N/C PO: PO35698	Line: 2
DATE: 28/03/2017 CERTIFIED SIGNATURE: RECEIVER SIGNATURE: _____			



A.T.G. INDUSTRIES INC.
731 INDUSTRIELLE STREET
ROCKLAND, ON K4K 1T2
Canada

Ph: (613) 446-4544

Fax: (613) 446-4556

Pack List

Number: 913105

Date: 28-Mar-17

To

Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ship To

Chantal Lavoie
Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ph: 613 632-9577

Fax: 613 632-1053

Ph: 613 632-9577

Fax: 613 632-1053

Terms

Ship Via

Quantity

Description

Note: This Packing Slip may contain parts that have been PLATED. Items that are plated may be subject to natural tarnishing and it is suggested that they be inspected within 24 hours of receipt.

CERTIFICATE OF CONFORMANCE

A.T.G. INDUSTRIES INC. CERTIFIES THAT ALL ITEMS IN THIS SHIPMENT CONFORM TO REQUIREMENTS.

MADE IN CANADA.

Sp 17-03-29